

Date: Thursday, 15/01/2009 11:13:29 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE WELDMENT
Job Number	: 44783		
Estimate Number	: 12064		
P.O. Number	:	Part Number	: D3355045 FR
This Issue	: 15/01/2009 S.O. No. :	Drawing Number	: D3355 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 44309	Material	:
Written By	:	Due Date	: 30/01/2009 Qty: 10x Um: Each
Checked & Approved By	: <u>JUD 09.01.15</u>		
Comment	: est rev A 06.01.20 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33551	Pin
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3355-1	handle tip	B44250 = 5x

B44899 = 5x
B44250 = 5x

SP 09.05.5

2.0	D33553	Large Tubing
-----	--------	--------------



(P10) →

Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	D3355-3	large tubing	B44250 = 6x

B44899 → 4x

SP 09.05.5

3.0	238043	DOWEL PIN .250 X 1.5
-----	--------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

pin

Batch: **B16084 = 20x**

SP 09.05.5

4.0	VA7130	spring plunger
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

qty	part number	description	batch
1	VA-7130	spring plunger	M103546 = 4x

M110573 = 2x

SP 09.05.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3355-045 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ✓ Date: 09/05/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 44783		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A D3353-3	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/5/5	2.0	Found Qty 40 Parts that were made with wrong mat. wall thickness is too thin measure 0.090" and are welder tubing not SEAM LESS	UP 09.05.07 P QSI 042	Dwg calls for ASTM A513 WHICH IS WELDED TUBE. WITH 0.090" WALL, I = 0.8718 in ⁴ , $\Rightarrow F > 1000$ lbs TO YIELD TUBE.	SH 09/05/14	S 09/05/14	UP 09.05.07 P QSI 042	S 09/05/05
		RL missed on w/o's B44895 x4 AND w/o 44251 x6 at inspection	UP 09.05.07 P QSI 042	$M_F \leftarrow \approx 35" \rightarrow \downarrow F = 1000 \text{ lbs}$ $36000 = M_C/I = F \cdot d \cdot C/I$ Acceptable.	SH 09/05/14	S 09/05/14	UP 09.05.07 P QSI 042	S 09/05/05

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 44783

Part Number: D3355045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



09/05/13

Comment: Weld assembly as per dwg

6.0

DO NOT USE

QC 9 &

WELD INSPECTION

SP 09-05
09-05-13

10x

7.0

POWDER COATING

POWDER COATING



M102391

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

110

START TIME:

11:10

OVEN TEMPERATURE:

320°

FINISH TIME:

11:40

umo

09/05/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-14 (10)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install spring plunger per dwg D3355

09/05/14 (10)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/14 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

57494 / 09/05/19 (10)
09/05/14 (10)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR
09-05-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

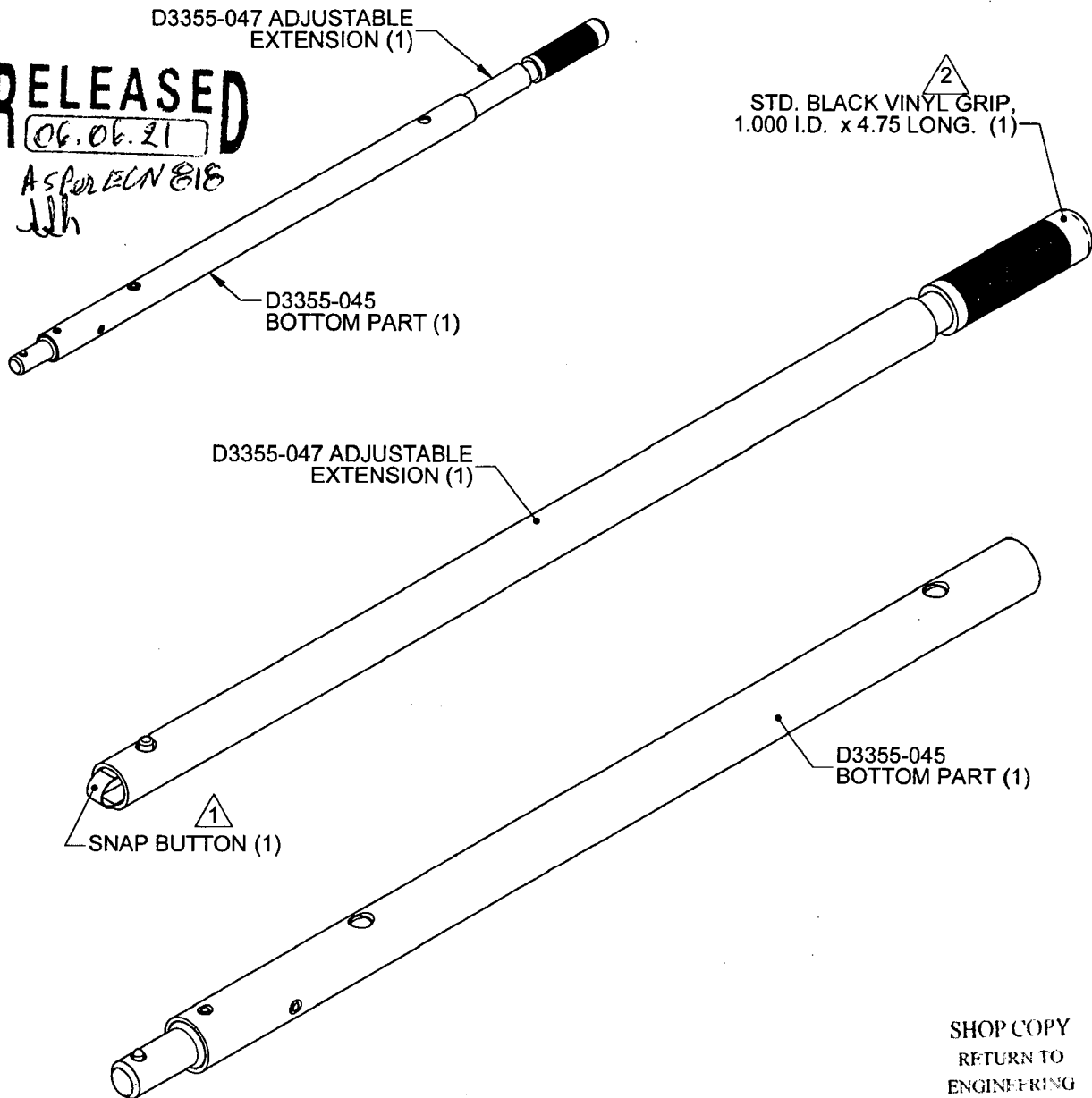
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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21

AS FOR ECN 818
[Signature]



D3355-041 HANDLE ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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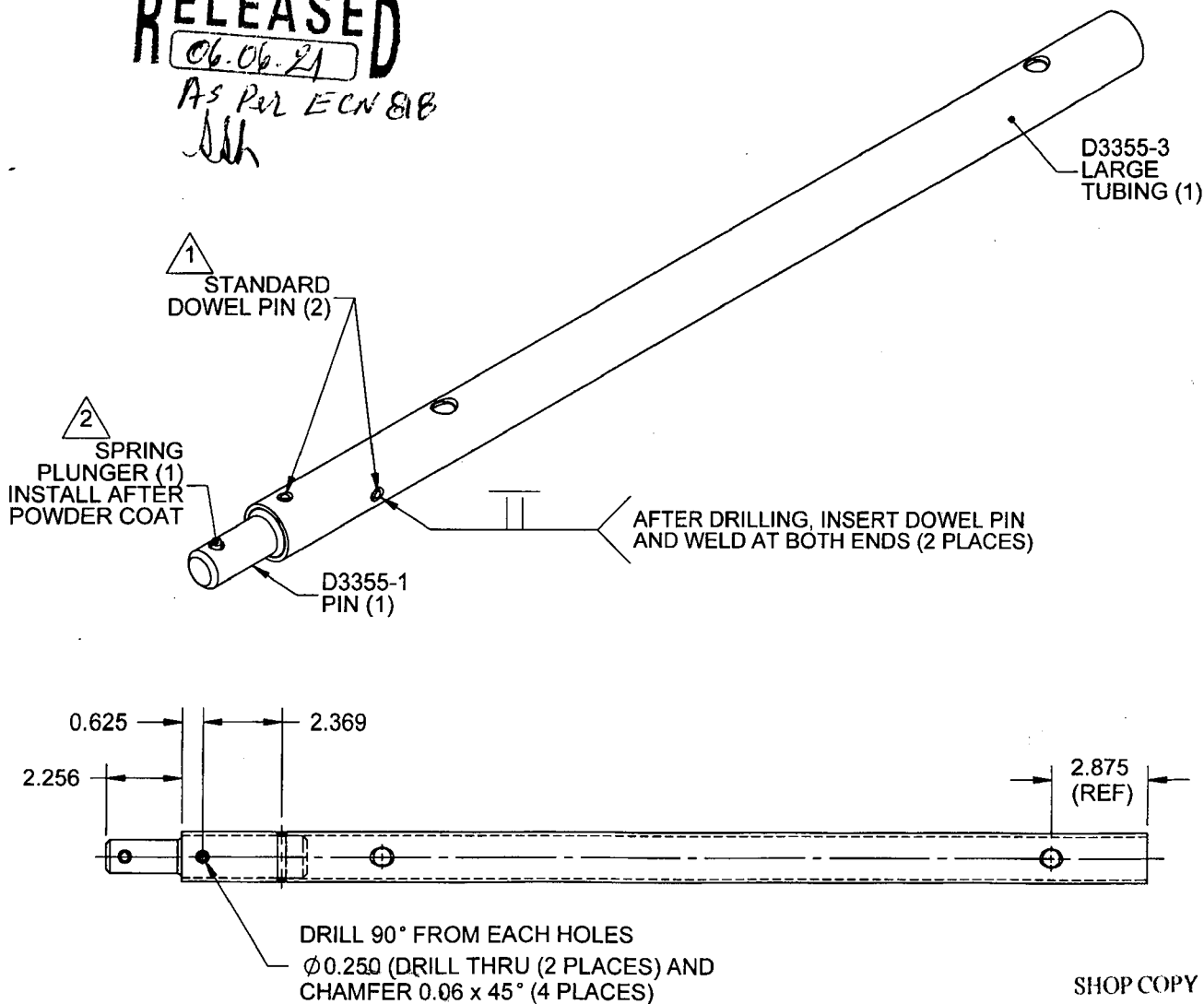
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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[Signature]**D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, $\varnothing 0.250 \times 1.50$ LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N IVA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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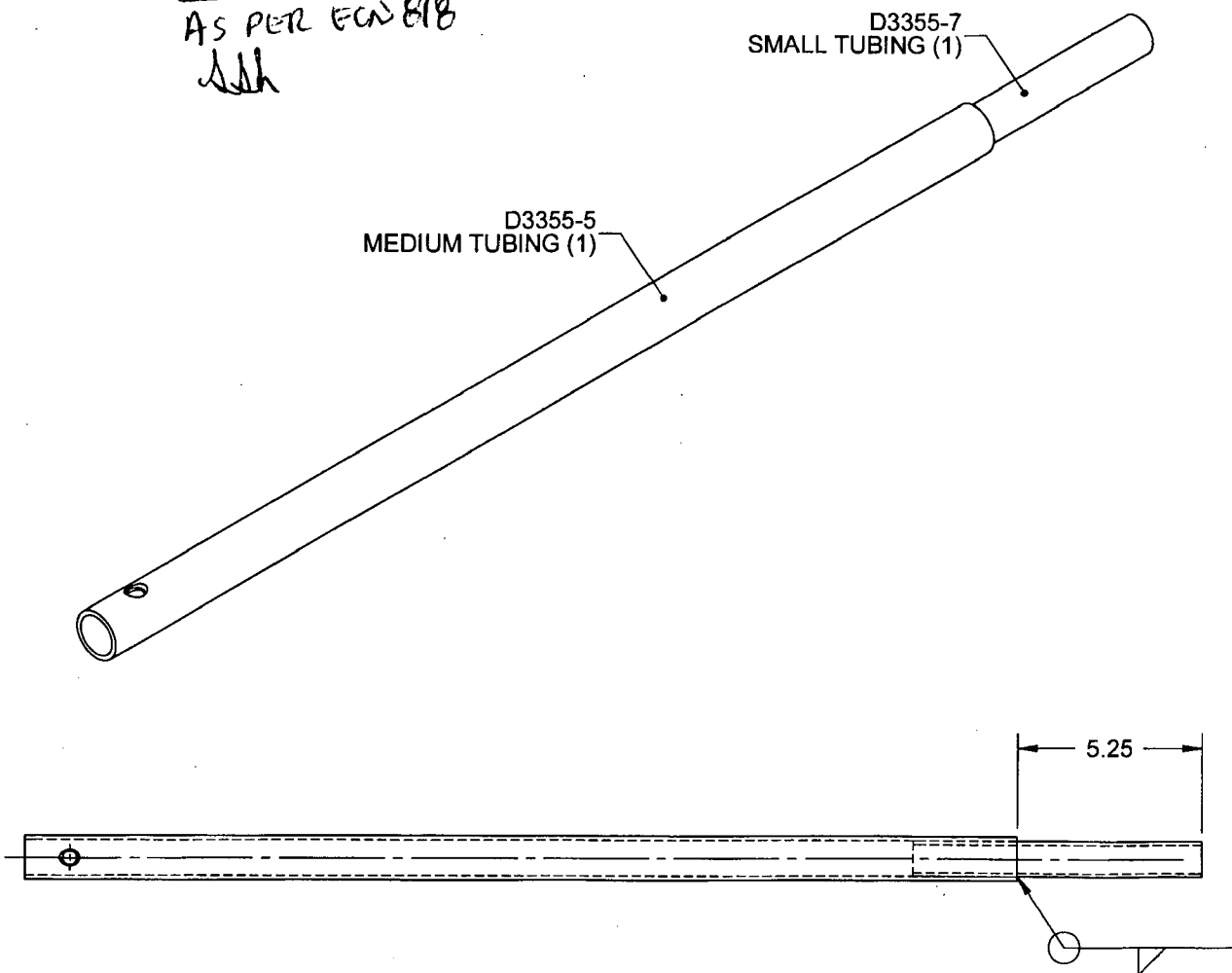


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D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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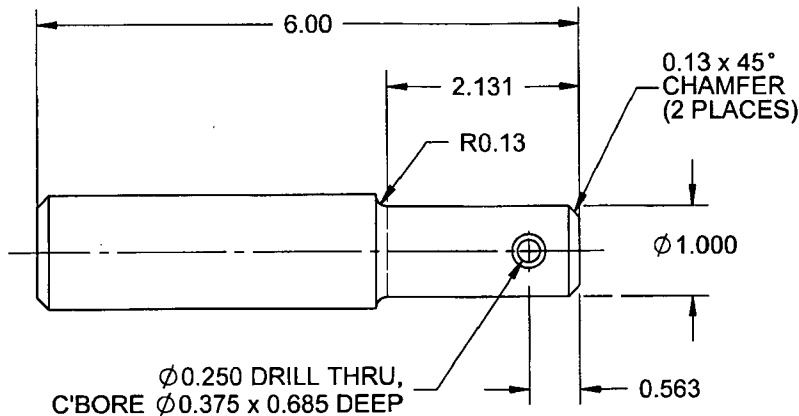
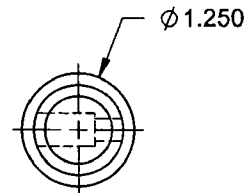
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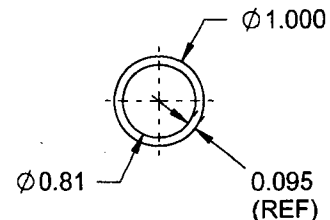
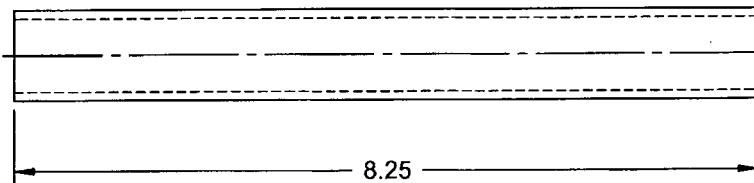
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**RELEASED**
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AS PER ECN 818**D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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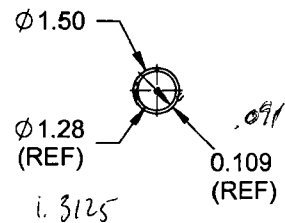
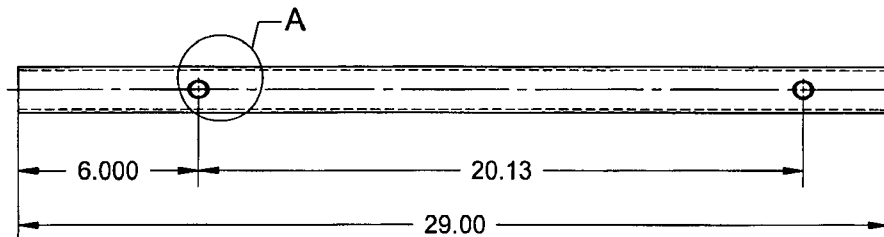
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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:6

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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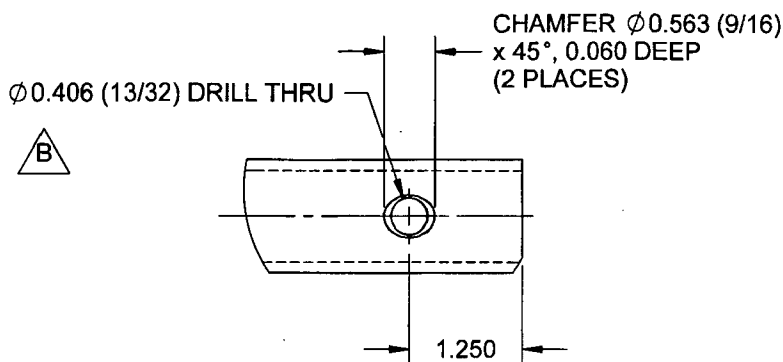
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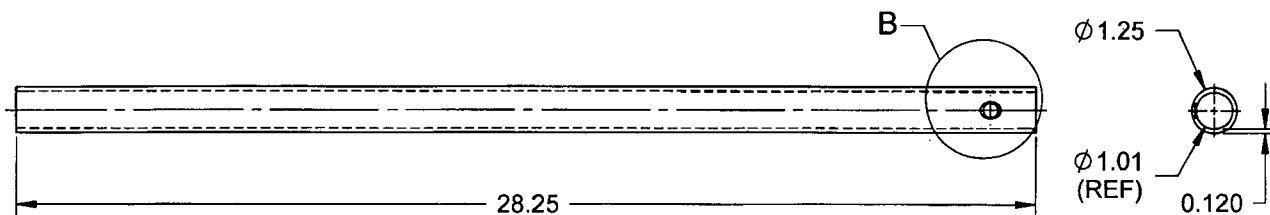


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DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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